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D2344**Job Sheet 206693****Part No:** D2344**Job Qty:** 12 pcs**Part Name:** Deck Plate Aft**Part Weight:** 0 lbs**Job Created:** 2/5/20**Due Date:** 3/20/20**Type:** Stock**Status:** New**Job Tracking No:****Created By:** Marie Lajeunesse**Description:****Priority:** Medium

Note: DWG REV F IPP Rev:D 00.06.26 Removed P/O for powder coat EC IPP Rev:E 07-07-04 Asper Rev F JLM
Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs			0.11	1.94	Waterjet - Flow		20/04/14
110	QC 2	12 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/04/14
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
QC 2 - 8									
QC 2 - 66									
QC 2 - 64									

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120 QC 8	12 pcs	0.00 0.00	QC 2 - 65	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
130 Small Fab - 2 - B4B	12 pcs	0.00 1.59	Small Fab - 1 - B4B	DAS 82 9-89 APR 14 2020
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
140 QC 5	12 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	

150 Handfinish - 1-1 Chemical-B4B	12 pcs	0.00 0.66	QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	QC 5-82
			Handfinish - 1 - 1 - B4B	APR 27 2020
			Handfinish - 1 - 2 - B4B	20.04.27
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
155 QC 7	12 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	20.04.27
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	

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160 Powdercoat - 4 Black Sand - B4B 12 pcs

0.00 0.43

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

START: 1:00

O/I: 320° FIMS/1:30

20-04-27

170 QC 3 12 pcs

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

QC 3 - 19

QC 3 - 43

QC 3 - 24

QC 3 - 61

QC 3 - 81

QC 3 - 82

BE820-0427

180 Packaging 3-1 - Stock - B4B 12 pcs

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

DAS

80

9-89

			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
190 QC 21 - SA	12 pcs	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-00

APR 28 2020

Part Op 100 - 1-Cut as per dwg prog rev: F dwg rev: F

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - (QC8- Inspect parts - second check)

130 - (Small Fab) 1-Deburr sharp edges 2-Countersink holes per Dwg D2344

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

155 - (QC7-Inspect Chemical Conversion Coat)

160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	8.9400 sf (.745 ea)	100-Waterjet - Flow - 1	5252405

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	9	172	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Litter Deck Plate Kit (350)	6.223Inches ± 0.010	6.233 6.213		6.228
2	Litter Deck Plate Kit (350)	5.598Inches ± 0.010	5.608 5.588		5.595
3	Litter Deck Plate Kit (350)	4.869Inches ± 0.010	4.879 4.859		4.860
4	Litter Deck Plate Kit (350)	3.889Inches ± 0.010	3.899 3.879		3.888
5	Litter Deck Plate Kit (350)	3.096Inches ± 0.010	3.106 3.086		3.089
6	Litter Deck Plate Kit (350)	2.891Inches ± 0.010	2.901 2.881		2.882
7	Litter Deck Plate Kit (350)	16.973Inches ± 0.010	16.983 16.963		16.973
8	Litter Deck Plate Kit (350)	0.450Inches ± 0.010	0.460 0.440		.443
9	Litter Deck Plate Kit (350)	4.423Inches ± 0.010	4.433 4.413		4.432
10	Litter Deck Plate Kit (350)	4.723Inches ± 0.010	4.733 4.713		4.725
11	Litter Deck Plate Kit (350)	1.202Inches ± 0.010	1.212 1.192		1.207
12	Litter Deck Plate Kit (350)	5.869Inches ± 0.010	5.879 5.859		5.867
13	Litter Deck Plate Kit (350)	4.654Inches ± 0.010	4.664 4.644		4.664
14	Litter Deck Plate Kit (350)	0.656Inches $+ 0.005$ $- 0.000$	0.661 0.656	Diameter	.656
15	Litter Deck Plate Kit (350)	1.888Inches ± 0.010	1.898 1.878		1.884
16	Litter Deck Plate Kit (350)	2.285Inches ± 0.010	2.295 2.275		2.285
17	Litter Deck Plate Kit (350)	2.683Inches ± 0.010	2.693 2.673		2.681
18	Litter Deck Plate Kit (350)	0.171Inches $+ 0.005$ $- 0.000$	0.176 0.171	Diameter	.171
19	Litter Deck Plate Kit (350)	3.491Inches ± 0.010	3.501 3.481		3.483
20	Litter Deck Plate Kit (350)	0.191Inches $+ 0.005$ $- 0.000$	0.196 0.191	Diameter	.191
21	Litter Deck Plate Kit (350)	3.123Inches ± 0.010	3.133 3.113		3.124
22	Litter Deck Plate Kit (350)	1.975Inches ± 0.010	1.985 1.965		1.982
23	Litter Deck Plate Kit (350)	0.128Inches $+ 0.005$ $- 0.001$	0.133 0.127	Diameter	.129

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Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QSI042)					
Description Work Order Deviation		Disposition							
		Completed By							
		Lead hand / Supervisor							
		QC / QA Coordinator							

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>										☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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